

Date: Friday, 2/23/2007 8:31:14 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING		
Job Number	: 30876					
Estimate Number	: 10826					
P.O. Number	: N/A		Part Number	: D23273		
This Issue	: 2/23/2007	S.O. No. : N/A	Drawing Number	: D2327 REV 0/D		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A	Type : MACHINED PARTS	Drawing Revision	: 0/D		
Previous Run	: 28597		Material	: N/A		
Written By	:		Due Date	: 3/30/2007	Qty:	50 Um: Each
Checked & Approved By	: <i>JL 02.23</i>					
Comment	: Est. F 05/11/02 Removed 303 SS KJ/EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0375	304 SS ROUND BAR	
		Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s) Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375) Batch: <i>M1023d1</i> <i>DJP</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr	<i>BL 07-05-08</i> <i>SL</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>BG 07-05-08</i> <i>SL</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>JL 07-05-08</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>EF 07-05-08 (57)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/15/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 30876

Part Number: D23273

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(57)

Comment: FINAL INSPECTION/W/O RELEASE

1/27/05/09

Job Completion



W. Johnston

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

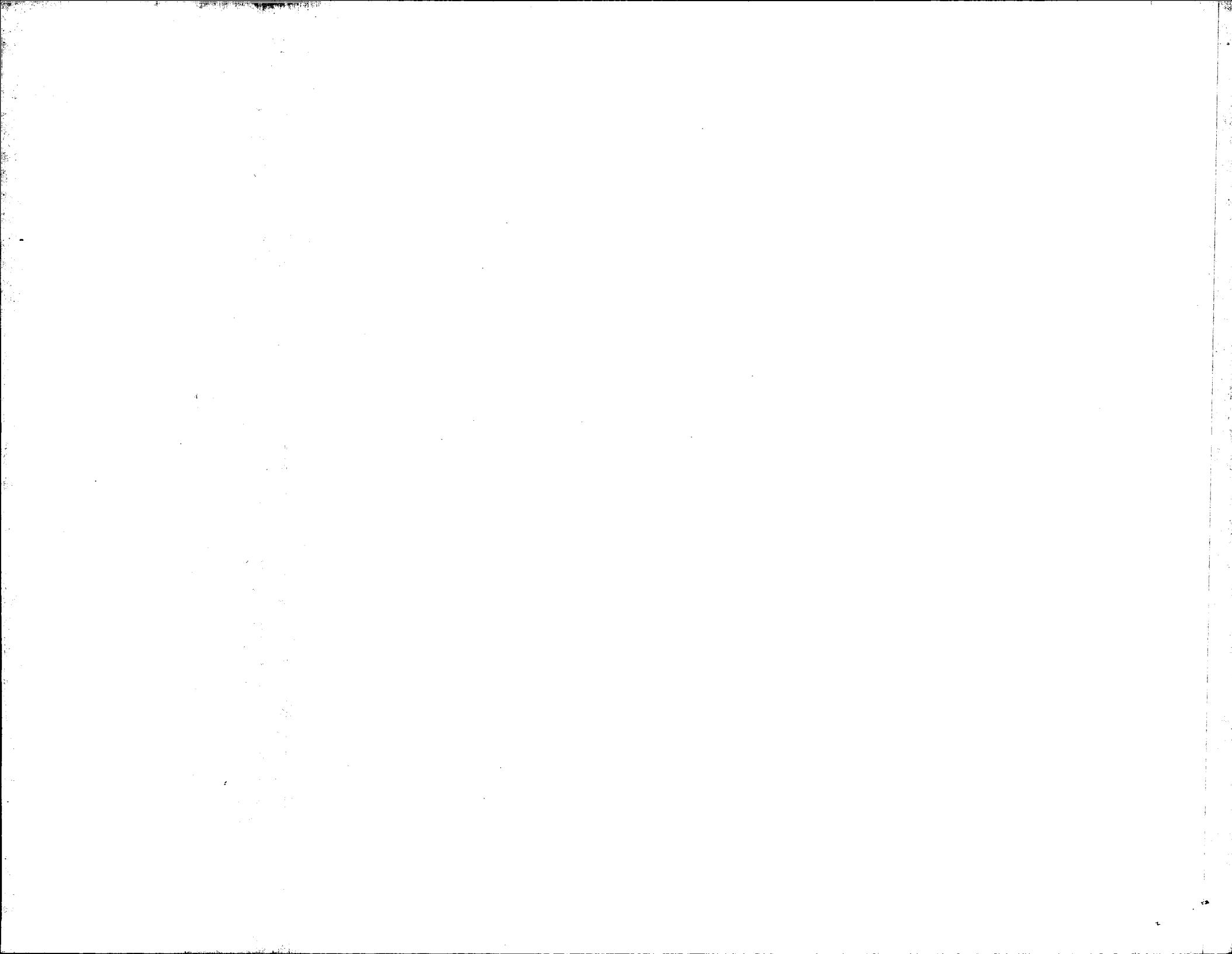
DART AEROSPACE LTD	Work Order:	30876
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

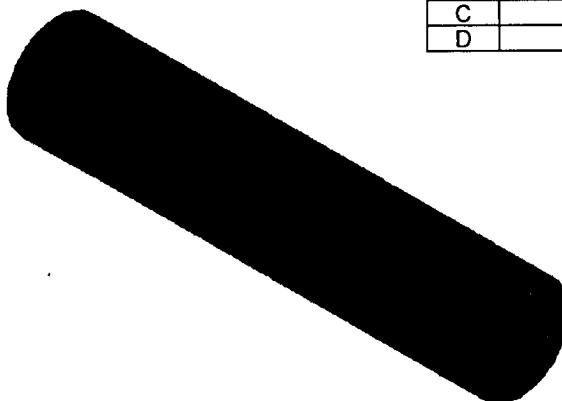
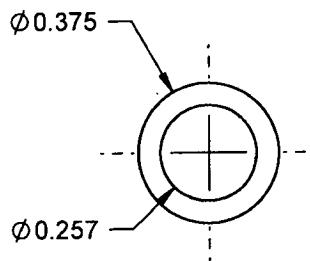
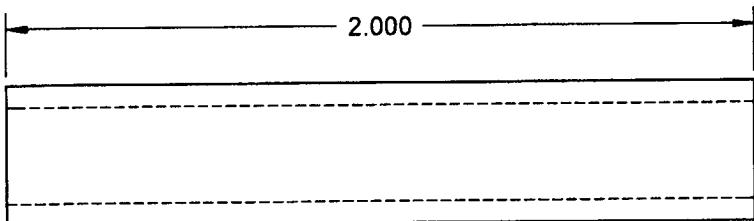
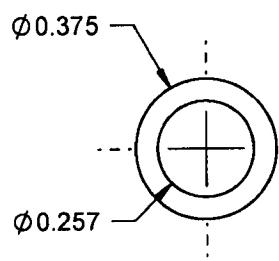
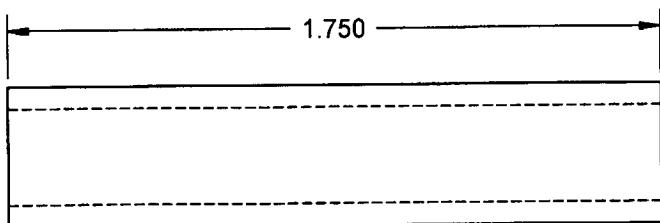
Measured by:	<u>BG</u>	Audited by:	<u>J.L.</u>	Prototype Approval:	N/A
Date:	<u>02.05.08</u>	Date:	<u>07/05/08</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	JK BE



DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	

**RELEASED**06.11.14 *[Signature]***D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30876
D